

Claims

1. A method for coating open-pored bodies with at least one coating suspension including, in particular, solids and solutes in a liquid medium, in a quantity in wet state which is to correspond to at least a required target quantity, wherein the coating operation includes a variation in the applied wet coating quantity from one body to the other, the method being characterized by the steps of:
 - (a) coating a body with an actual quantity of the coating suspension, which is always larger than the required target quantity taking the variation of the coating operation into account,
 - (b) determining the difference between the actual quantity and the required target quantity, and
 - (c) reducing the difference between actual quantity and target quantity by removing still wet coating suspension.
2. The method according to claim 1, wherein steps (a) to (c) are followed by drying and calcination of the applied coating suspension.
3. The method according to claim 2, wherein step (c) includes reducing the difference between actual quantity and target quantity by re-suction from one end of the body using an intensity and/or duration matched with the magnitude of the differential quantity.
4. The method according to claim 3, wherein intensity and/or duration of re-suction are selected from tables of values for the measured actual quantity established in preliminary tests.

5. The method according to claim 4, wherein duration and/or intensity of re-suction are controlled in accordance with the values for the actual quantity, duration and/or intensity determined for the bodies coated immediately before, and the associated reduction obtained in the difference between actual and target quantities.
6. The method according to any of the preceding claims, wherein the actual quantity is determined by weighing the body before and after coating.
7. The method according to any of claims 1 to 6, wherein steps (b) and (c) are run at least twice until the actual quantity is within a previously specified tolerance range above the target quantity.
8. The method according to claim 7, wherein re-suction is performed from the second end of the body during the second run.
9. The method according to claim 6, wherein the reduction in the difference between actual quantity and target quantity in step (c) is performed only if said difference exceeds a previously specified threshold value.
10. The method according to claim 7, wherein the reduction in the difference between actual quantity and target quantity in step (c) is performed only if said difference exceeds a previously specified threshold value and said threshold value is reduced after each run.
11. Apparatus for coating open-pored bodies with at least one coating suspension including, in particular, solids and solutes in a liquid medium, in a quantity in wet state which is to correspond to at least a required target quantity, wherein the coating operation includes a variation in the applied wet coating quantity from one body to the other, the apparatus, in particular,

being for a method according to at least one of the preceding claims, comprising:

- (a) a coating station (20) for coating the body with an actual quantity of the coating suspension, which is always larger than the required target quantity taking the variation of the coating operation into account,
- (b) weighing stations (30, 50) for determining the difference between the actual quantity and the required target quantity, and
- (c) a re-suction station (40) for reducing the difference between actual quantity and target quantity by removing still wet coating suspension.